

Work Order ID 72854

Tuesday, August 16, 2011 11:57:51 AM



Page 1

Item ID: D350-589-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Side Door Latch Modification

Start Date: 8/16/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 8/30/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: MUF

Date: 11-08-17

Tooling:

Date:

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

INN-D350-589

E

100



DOCUMENT CONTROL

0.00

DC

Memo

0.00

Document Control

Photocopy blue file and type label as per PPP D350-589-011 CHG002

8/10/31

11/8/30 BG 11-8-17 (4)

105



Pick Kit

0.00

Packaging

Memo

0.00

Packaging

11/8/30 SP (4)

110



QC4- 100% Inspect kits for completeness

0.00

QC

Memo

0.00

Quality Control

8/10/31

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Customer:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Packaging	0.00							
	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per QSI 014								
130	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11/6/31 SP

42

Reof

11/9/11

MF 11-08-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

Tuesday, August 16, 2011 11:57:48 AM

Page 1

Work Order ID: 72854

Parent Item: D350-589-011

Parent Item Name: Side Door Latch Modification

Start Date: 8/16/2011

Required Date: 8/30/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP F02.08.29 Removed D2587 Plug KJ
ALL AT CHANGE 002

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960JD10 Washer	NAS1149D0363J	Purchased	No			105	Each	0.0000	3	12			
D2237 Striker Plate		Manufactured	No			105	Each	44.0000	3				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST009		44							
				66139		6							
				70558		38							
D2583 Latch Bracket		Manufactured	No			105	Each	39.0000	3				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST017		39							
				70559		39							
D2585 Mounting Channel		Manufactured	No			105	Each	54.0000	3				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST017		54							
				70814		54							

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 72854

Parent Item: D350-589-011

Parent Item Name: Side Door Latch Modification

Start Date: 8/16/2011

Required Date: 8/30/2011

Start Qty: 4.00

Required Qty: 4.00

D2586

Manufactured No

105 Each

74.0000

3



Door Latch

Location

Loc Qty

Loc Code

ST204

74

64774

24

70557

50

D2587

Manufactured No

105 Each

10.0000

1



Door Slug, 350 Hinge

Location

Loc Qty

Loc Code

ST017

10

66836

10

D2589

Manufactured No

105 Each

83.0000

1



Keys, Key Chain, 350 Hinge

Location

Loc Qty

Loc Code

ST018

83

58194

83

MS20470AD4-5

Purchased

No

105 Each

3,163.000

6



Rivet, Universal Head

Location

Loc Qty

Loc Code

ST319

3163

116893

195

118405

2968

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Tuesday, August 16, 2011 11:57:49 AM

Work Order ID: 72854

Parent Item: D350-589-011

Parent Item Name: Side Door Latch Modification

Start Date: 8/16/2011

Required Date: 8/30/2011

Start Qty: 4.00

Required Qty: 4.00

MS21042L3

Purchased

No

105

Each

1,915.000

3

12



SP

S
41

Nut

Location

Loc Qty

Loc Code

ST300

1915

117441

270

117601

400

117885

245

118451

1000

12

MS27039-1-15

Purchased

No

105

Each

139.0000

3

12



SP 11/15/31

S
41

Screw

Location

Loc Qty

Loc Code

ST292

139

116916

14

118093

25

118574

100

3
5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

52.4 PARTS LIST

589 -011	589 -041	589 -042	589 -043	Part Number	Description
X				D350-589-011	SIDE DOOR LATCH MODIFICATION KIT
	X			D350-589-041	SIDE DOOR ASSEMBLY, LH AS 350
		X		D350-589-042	SIDE DOOR ASSEMBLY, RH AS 350/355
			X	D355-589-043	SIDE DOOR ASSEMBLY, LH AS 355
	1			D2991-1	Door
		1		D2991-2	Door
			1	D2991-3	Door
3	3	3	3	D2237	Striker Plate
	1	1	1	D2464-1700	Seal
3				D2583	Latch Bracket
3	3	3	3	D2585	Latch Clamp
3	3	3	3	D2586	Latch
1				D2587	Plug
1	1	1	1	D2589	Keys, Key Chain
	3	3	3	D2621	Latch Plate
	2**	2**	2**	D2992-1	Doubler
	1	1	1	D3085-041	Prop Assembly
	1*	1*	1*	D3015-3	Locknut
	1*	1*	1*	D3081-1	Prop Hinge
	1*	1*	1*	D3082-1	Clip
	1*	1*	1*	D3084-1	Prop Arm
	1*	1*	1*	AN4-5A	Bolt
	3*	3*	3*	AN960JD10	Washer
	3*	3*	3*	AN960JD10L	Washer
	2*	2*	2*	AN960JD416	Washer
	1*	1*	1*	AN960JD516L	Washer
	3*	3*	3*	MS21042L3	Nut (or MS21042-3)
	1*	1*	1*	MS21042L4	Nut (or MS21042-4)
	3*	3*	3*	MS27039-1-13	Screw
	1*	1*	1*	SL69-BS	Ball Stud
	6	6	6	AN3-4A	Bolt
3	3	3	3	AN960JD10	Washer
3	9	9	9	MS21042L3	Nut (or MS21042-3)
6	6	6	6	MS20470AD4-5	Rivet
3	3	3	3	MS27039-1-15	Screw

* Reference only. Included in D3085-041 Prop Assembly listed above.

** Reference only. Included in D2991-1/-2/-3 Doors listed above.

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